

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1-17. (Canceled)

18. (New) A method for manufacturing a header for a heat transfer apparatus, comprising:

providing a tube having an outside diameter (D), and outside radius (D/2), and a wall thickness (s);

punching the tube without an internal die

(i) to form a slot in the tube,

(ii) to provide a tube having a ratio (D/2:s) of the tube's outside radius (D/2) to the tube wall thickness (s) of less than 5, and

(iii) to provide a tube having a ratio (D:D1) of the tube outside diameter (D) outside of the region of the slot to the tube diameter in the region of the slot (D1) of between 1.02 and 1.5

spot heat treating and/or mechanically weakening the tube in the region to be punched before the step of punching.

19. (New) A method according to claim 18, wherein the step of providing a tube comprises:

providing a flat material having a first longitudinal side and a second longitudinal side;

bending the flat material so that the first longitudinal side and the second are adjacent to one another and define a longitudinal gap; and

closing the longitudinal gap by welding or soldering.

20. (New) A method according to claim 19, wherein, in addition to the step of closing the longitudinal gap by welding or soldering, the method further comprises welding or soldering a plurality of joints for the construction of the heat transfer apparatus, and wherein the step of closing the longitudinal gap and the step of welding or soldering the plurality of joints takes place in a single welding or soldering step.

21. (New) A method according to claim 18, wherein the flat material comprises a solder-plated flat material.
22. (New) A method according to claim 18, wherein the step of punching comprises internal, high-pressure punching.
23. (New) A header produced by the method of claim 18.
24. (New) A heat transfer apparatus comprising a flat tube and a header according to claim 23.
25. (New) A motor vehicle comprising a heat transfer apparatus according to claim 24.
26. (New) A header for a heat transfer apparatus, comprising:
 - a tube having an outside diameter (D), a wall thickness (s) and an outside radius (D/2); and
 - a slot for the insertion of a flat tube;
 - wherein a ratio (D/2:s) of the tube's outside radius (D/2) to the tube wall thickness (s) is less than 5, and
 - wherein a ratio (D:D1) of the tube outside diameter (D) measured outside the region of the slot to the tube outside diameter (D1) measured in the region of the slot is between 1.02 and 1.5.
27. (New) A header according to claim 26, wherein the header comprises a material having a hardness between 35 Hv and 80 Hv.
28. (New) A header according to claim 26, wherein the tube comprises a non-circular cross section.

29. (New) A header according to claim 28, wherein the tube comprises a rectangular, square, semicircular or oval cross section.
30. (New) A header according to claim 26, wherein the tube comprises a plurality of chambers.
31. (New) A header according to claim 26, wherein the tube comprises one or more transverse partitions.
32. (New) A header according to claim 26, wherein the tube comprises a weld or seal-solder seam.
33. (New) A header according to claim 26, wherein the slot is arranged at an angle of more than 0 degrees to less than 90 degrees with respect to a longitudinal mid-plane of the tube.
34. (New) A header according to claim 26, further comprising a mechanical weakening provided at place at which the slot was made.
35. (New) A header according to claim 26, wherein the header comprises a plurality of slots.
36. (New) A header according to claim 35, wherein the header comprises at least two circumferentially adjacent slots.
37. (New) A heat transfer apparatus comprising a flat tube and a header according to claim 26.
38. (New) A motor vehicle comprising a flat tube and a header according to claim 37.